



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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RBW1205G00332-3G

Job Sheet 197627



Part No: RBW1205G00332-3G

Job Qty: 2 pcs

Part Name: Main Gear Box Oil Draining Hose



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/11/19

Job Tracking No:

Due Date: 8/9/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBW1205G00332-3G Rev 6 IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	8/9/19		0.00	2.67	Small Fab - 1		
							Small Fab - 2		MLC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	8/9/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	2 pcs	8/9/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Container No: S202095



Part: RBW1205G00332 - 3G

Job No: 197627

Serial No/Batch: S202095

Revision: 6

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/31/19

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				Packaging 3 - 6 - B4B					
				Packaging 3 - 7 - B4B					
				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				140 QC 21 - FG	2 pcs	8/9/19	0.00 0.00	QC 21 - FG - 21	
								QC 21 - FG - 70	
								QC 21 - SA - 53	

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Part Op **100** - Small Fab - 1-Cut 9657k135 (-25) spring to 0.5" as per work order deviation 2-Assemble as per DWG sheet 1.
 Descriptions: **110** - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location:
140 - QC21- Final Inspection - Work Order Release

Job BOM

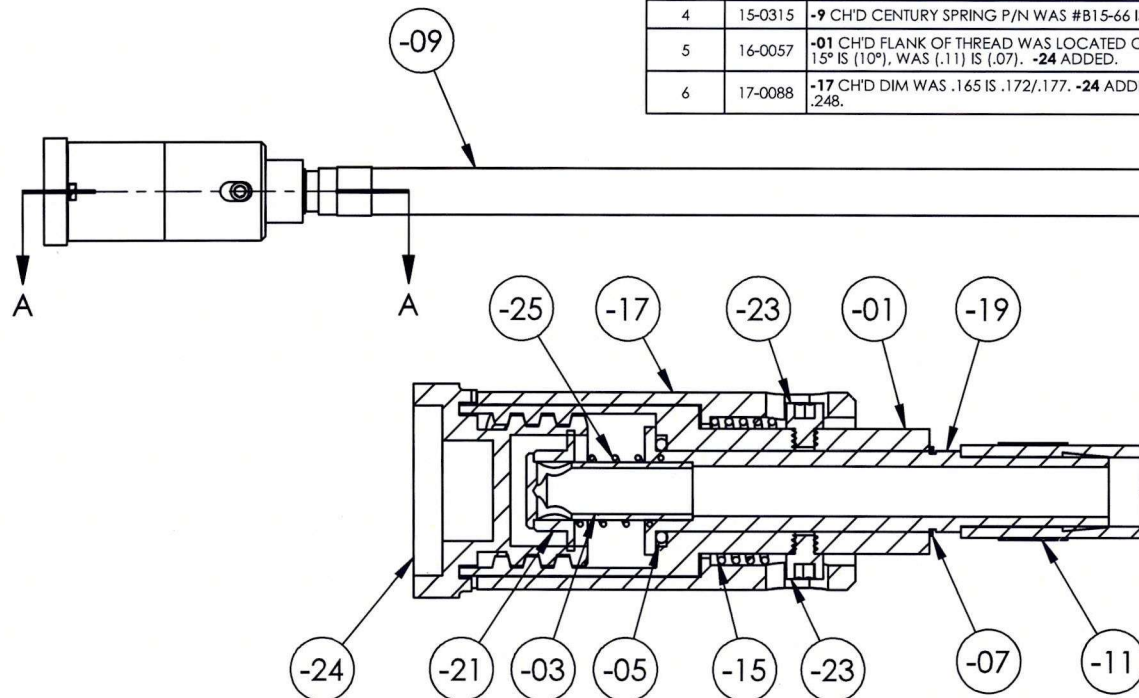
Part / Item	Component Name	Quantity	Operation	Container
1315	Crimp Hose Clamp 9/16"	2 pcs (1 ea)	100-Small Fab - 1	5035900
2619	Spring Rnd 3/4"	2 Ea (1 ea)	100-Small Fab - 1	5075045
4464T123	O-Ring 9/16 Od X 1/16 Cross	2 Ea (1 ea)	100-Small Fab - 1	5048577
91665A350	Retaining Ring, 7/16" Shaft	2 Ea (1 ea)	100-Small Fab - 1	5200936
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	12 ft (6 ea)	100-Small Fab - 1	5199490
RBW1205G00332-3G-01	Cap	2 pcs (1 ea)	100-Small Fab - 1	5137030
RBW1205G00332-3G-03	Quill	2 pcs (1 ea)	100-Small Fab - 1	5139008
RBW1205G00332-3G-17	Sleeve	2 pcs (1 ea)	100-Small Fab - 1	5136972
RBW1205G00332-3G-19	Barb	2 pcs (1 ea)	100-Small Fab - 1	5140398
RBW1205G00332-3G-21	Valve	2 pcs (1 ea)	100-Small Fab - 1	5137144
RBW1205G00332-3G-23	Screw (Modified B/O)	4 pcs (2 ea)	100-Small Fab - 1	5147938 3x 5183448
RBW1205G00332-3G-24	End Cap	2 pcs (1 ea)	100-Small Fab - 1	5137017
9657K135	Spring	2 Ea (1 ea)	100-Small Fab - 1	5097612

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	1315	2	45	0
	2619	2	27	0
	4464T123	2	34	0
	91665A350	2	6	0
	9657K135	2	5	0
	K010-0608	12	181	0
	RBW1205G00332-3G-01	2	6	0
	RBW1205G00332-3G-03	2	10	0
	RBW1205G00332-3G-17	2	2	0
	RBW1205G00332-3G-19	2	8	0
	RBW1205G00332-3G-21	2	7	0
	RBW1205G00332-3G-23	4	17	0
	RBW1205G00332-3G-24	2	6	0
Part Specifications				
Specifications could not be found.				

Plex 7/11/19 11:10 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDESIGNED WITH SHUTOFF AND RETAINING SLEEVE, ADDED PARTS -03, -17, -19, -21 & -23.	3/2/2011	JAG	
2		-01 CH'D TO CLEAR ANODIZE, THREAD CORRECTED TO 13/16-6. -03 CH'D HOLE FROM Ø.20, CH'D LIMIT DIM FROM Ø.3135-.3139. -17 CH'D TO CLEAR ANODIZE. -19 CH'D HOLE DIA. FROM Ø.26 AND .10 FLANGE TO .06. -21 CH'D Ø.313 TO LIMIT DIM S.F.	11/30/2011	RJC	DW
3		-17 ADDED ENGRAVE NOTE. -23 CH'D O.D. FROM Ø.20 TO Ø.200 +.003 -.000.	2/15/2012	RJC	SE
3A		-13 DELETE, ENGRAVING IS ON -17.	5/2/2013	RJC	RJC
4	15-0315	-9 CH'D CENTURY SPRING P/N WAS #B15-66 IS #2619.	9/30/2015	RJC	JAG
5	16-0057	-01 CH'D FLANK OF THREAD WAS LOCATED ON CENTERLINE IS OFFSET 13° FROM CENTERLINE; WAS 15° IS (10°), WAS (.11) IS (.07). -24 ADDED.	6/16/2016	SM	JAG
6	17-0088	-17 CH'D DIM WAS .165 IS .172/.177. -24 ADDED DIM'S .696, Ø1.09, MIN. R. DELETED DIM'S 2X .068, .248.	4/17/2017	RJC	JAG



SECTION A-A
SCALE 1 : 1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197627 M15
190711

NOTE:
FUNCTION: PART OF HELICOPTER SERVICING KIT PART No 3G1205G00131. USED TO DRAIN OIL FROM THE MGB THROUGH THE PARKER STRATOFLEX COUPLING, RBW1205G00332-3G REPLACES STRATOFLEX (11362) (A3Q07) P/N 165006.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-01	1	CAP	6061		2
			-03	1	QUILL	303/304 S.S.		3
		B/O	-05	1	O-RING	BURNA-N	9/16 OD X 1/16 CROSS (MCMaster-CARR #4464T123)	1
		B/O	-07	1	EXTERNAL RETAINING RING	SPRING STEEL	Ø7/16 SHAFT MCMaster-CARR #91665A350	1
		B/O	-09	1	HOSE	VINYL	Ø1/2 X 3/8 X 6 FT. KURI-TECH #K010-0608	1
		B/O	-11	1	CRIMP HOSE CLAMP	S.S.	Ø1/2 DIXON VALVE #OET-1315	1
		B/O	-15	1	SPRING	SPRING STEEL	Ø3/4 CENTURY SPRING #2619	1
			-17	1	SLEEVE	6061		4
			-19	1	BARB	303/304 S.S.		5
			-21	1	VALVE	303/304 S.S.		6
			-23	2	SCREW	S.S.	6-32 X 1/8 (MCMaster-CARR #92196A139) MODIFIED	7
			-24	1	END CAP	6061		8
		B/O	-25	1	SPRING	MUSIC WIRE	Ø.028 WIRE: Ø.360 OD X .5 FREE LENGTH RIED #S1165	1

DART
AEROSPACE

TITLE
MAIN GEAR BOX DRAIN TOOL

DWG NO. RBW1205G00332-3G

REV
6

MAT'L
HEAT TREAT
FINISH
SPEC
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 5°
.X ± .1 SURFACES = 125/
1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

DRAWN BY: PERRITT

CHECKED: DUERFELDT

OPPS APPR: ANDERSON

QA APPR: LINDSAY

APPROVED: GILBERT

USED ON MODEL

AGUSTA

SCALE 1:2

DATE 2/23/2011

SHEET 1 OF 8

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					